Chamfering Insert, Form-Chipbreaker

A8-010

On this chamfering Insert the chipbreaker has to follow the edge of the profile in order to maintain aequivalent cutting conditions while turning. To be able to follow the concave form the used wheel has to be small. The optional high speed spindle available on SCHNEEBERGER machines is required.

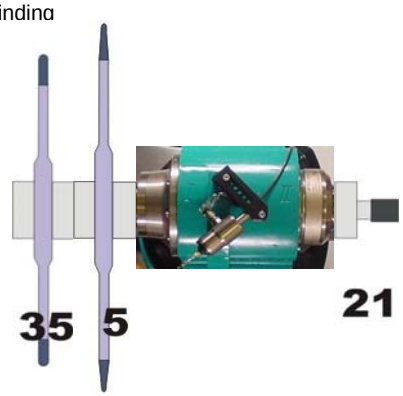
1. Cycletime for Production

Tool specifications BxH 5x16 mm, Radius 2.5 mm Material CARBIDE					
Operations	Probe	Chipbreaker	Prf Rough	Prf Pregr 2. cl	Prf fin 1. clr
Feed [mm/Min]	2000	120	30	45	60
Power [kW]		1	2	1	1
Cutting feed [m/s]		12	22	22	22
Used wheels		21	35	35	5
Grinding time [s]	11	82	49	47	41
Total cycle time		3 Min 50			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

21	1A1 Ø12 D64
35	14F1 Ø150 D76
5	14EE1 Ø200 D76 M



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: OP,27.3.09

www.schneeberger.ch
J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY FOR TOOLING